

## ABSTRACT

Using a metal mold (20a) consisting of a convex mold part (21a) and a concave mold part (22a), a molding material (14) is placed between a pair of coating films (12), and after  
5 claming, the molding material (14) and the coating film (12) are heated and molded to make a biodegradable expanded molded article, and at the same time, the coating film (12) is softened and pressure-bonded to a surface of the biodegradable expanded  
10 molded article. An exhaust hole (31a) and (32a) are provided on the convex mold part (21a) and the concave mold part (22a), respectively. At the time of heating and molding, gaseous matter existing between the coating film (12) and a surface of the metal mold (20a) is discharged out of the metal mold (20a) through the exhaust holes (31a) and (32a). Accordingly,  
15 it is possible to provide a method and a mold to manufacture a biodegradable expanded molded article easily and with excellent accuracy of dimension, having enough strength, enough water resistance, very excellent biodegradability and excellent surface smoothness even if the biodegradable molded  
20 article has a complicated shape.